

**What is claimed is:**

1. An oral solid dosage form, comprising
  - a) a core portion having sufficiently low friability to receive a printed  
5 or etched marking on a surface thereof;
  - b) a readable printed or etched marking on the surface of said core,  
said marking providing identification/authentication of said oral dosage form.
2. The oral solid dosage form of claim 1, wherein said core is film coated  
10 prior to said printed or etched marking being applied thereto.
3. The oral solid dosage form of claim 1, wherein said printed or etched  
marking is a bar code.
- 15 4. The oral solid dosage form of claim 3, wherein said bar code is a 2D data  
matrix bar code.
5. The oral solid dosage form of claim 2, wherein said film coat contains a  
colorant.  
20
6. The oral solid dosage form of claim 1, wherein said marking is readable  
with a bar code scanner.
7. The oral solid dosage form of claim 1, wherein said marking is readable  
25 with detection equipment which does not depend upon visible light waves.
8. The oral solid dosage form of claim 1, further comprising a covert marking  
thereon.
- 30 9. The oral solid dosage form of claim 1, wherein said covert marking is  
detectable by aroma or taste.

10. The oral solid dosage form of claim 8, wherein said covert marking is detectable using HPLC.
- 5 11. The oral solid dosage form of any of claims 1-10, wherein the surface of said core further comprises a debossed region into which said printed or etched marking is placed.
12. The oral solid dosage form of claim 11, wherein said debossed region has a  
10 substantially horizontal plane with respect to the center of said core.
- 13 The oral solid dosage form of claim 1, wherein said core has an ink coating applied to a portion thereof prior to said marking being applied thereto.
- 15 14. A method of applying a readable printed or etched marking which provides identification/authentication criteria on the surface an oral solid dosage form, comprising
- a) providing a pharmaceutically acceptable core portion having sufficiently low friability to receive a printed or etched marking on a surface  
20 thereof;
- b) applying a readable printed or etched marking on the surface of said core. said marking of said oral dosage form.
15. The method of claim 14, wherein said marking is applied via pad printing.  
25
16. The method of claim 14, wherein said marking is applied via ink jet printing.
17. The method of claim 14, wherein said marking is etched onto a surface of  
30 said core.

18. The method of claim 14, further comprising debossing a surface region of said core and applying said marking in said debossed region.
19. The method of claim 14, further comprising film coating the surface of said  
5 the core prior to applying said marking.
20. The method of claim 14, further comprising applying a covert marking to said core.
- 10 21. The method of claim 20, wherein said printed marking is applied using an ink containing a covert marker therein.
22. The method of claim 15, wherein said pad printing is applied using an  
Opacode ink.  
15
23. The method of claim 20, wherein the concentration of said covert marker is applied to the film coating in an amount sufficient to provide about 2 to about 5 ppm per tablet marked.
24. The method of claim 23, wherein the concentration of said covert marker is  
20 sufficient to provide about 4 ppm per tablet marked.